

**D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD (SHOWN)**  
**D3887-043 STANDARD SKIDTUBE ASSY WITH WEAPLATE (SIMILAR)**  
**D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-1 WEB  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3887-041 = 32.0 lbs  
D3887-043 = 37.0 lbs  
D3887-045 = 38.1 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES  
ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT  
PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT  
PORTION OF THE TUBE.
- 10) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE  
WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO  $\varnothing 0.197$  HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8931 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARPLATE INSERTS.  
INSTALL AELS-1032-130 INTO D3887-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS  
WITH SIKAFLEX-241/-291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3887-041	STD SKIDTUBE ASSY WITH WEARPAD
2		X		D3887-043	STD SKIDTUBE ASSY WITH WEARPLATE
3			X	D3887-045	STD SKIDTUBE ASSY WITH TRAINING WEARPLATE
10	2	2	2	D2579	CROSS BOLT SPACER
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	2	2	2	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	5			D3846-1	GASKET
16	1			D3846-11	GASKET
17	5	5		D3847-1	WEARPAD
18	1	1		D3847-11	AFT WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEAPLATE ASSY
21		1		D3847-047	AFT WEARPLATE ASSY
22			1	D3849-041	FWD TRAINING WEARPLATE ASSY
23			1	D3849-043	AFT WEARPLATE ASSY
24	1	1	1	D3885-1	STANDARD WEB
25	1	1		D3887-11	STANDARD SKIDTUBE
26			1	D3887-13	STANDARD SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
41	30	30		ALS4-1032-130	INSERT
42	32	32	2	AN3C5A	BOLT
43			8	AN3C46A	BOLT
44	32	32		NAS1149C0332R	WASHER (OR AN960C10L)
45			8	MS21043-3	NUT
46	2	2	2	MS24694-C52	SCREW

RELEASED  
2013-03-19

C	(SHT1, P/L, ZN C2-2, C3-2, C4-2) ITEM 13, QTY 2 WAS 4, ITEM 42, QTY 32 WAS 34, ITEM 44, QTY 30 WAS 32, ADD ITEM 46, MS24694-C52 WAS AN3C5A, 2 PLCS, (ZN C1-5, C1-6, B4-7) $\varnothing 0.201$ CSK $\varnothing 0.385 \times 100$ WAS $\varnothing 0.214$ THRU, ADDED DETAIL F (ZN C8-5, C8-6, B8-7), ADD ITEM 10, D2579 CROSS BOLT SPACER (ZN D4-1, A6-7)	DB	13.02.19
B	ALS4-1032-130 WAS AELS-1032-130 (ZN C4-1, C5-7, C3-7); ADD DT8931 (ZN A8-1); ADD 134.04 (ZN C4-8); D2855-3 WAS D2575 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C6-2, C2-2, C6-3, C2-3, C6-4, C2-4); $\varnothing 0.313$ WAS $\varnothing 0.328$ (ZN C4-5, C4-5, C2-7 & B3-7) REVISED NOTE iv (ZN B3-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DS	D3887	SHEET 1 OF 8
APPROVED	MS	TITLE	SCALE
DE APPR.	TH	A119 STD SKIDTUBE ASSY	NTS
DATE	13.02.19	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

AN3C5A BOLT  
D3672-1 PHENOLIC WASHER  
NAS1149C0332R WASHER  
(1 PER SIDE)

SEAL WITH  
SIKAFLEX-241/291

D2855-3 CAP

D3846-11  
GASKET

D3847-11  
WEARPAD

1.5  
1.5  
1.5

2.00 DISTANCE TO D3885-1 WEB, REF

BLACK ANTI-SKID TO 0.5  
ABOVE LOCATION RIDGE  
TYP

11  
Ø0.197  
8 PL PER SIDE  
REF

1.5  
1.5

AN3C5A BOLT  
NAS1149C0332R WASHER  
24 PL

PLUG UNUSED INSERTS WITH  
AN3C5A BOLT  
NAS1149C0332R WASHER  
6 PL

D3846-1  
GASKET  
5 PL

D3847-1  
WEARPAD  
5 PL

D2855-3 CAP

SEAL WITH  
SIKAFLEX-241/291

C  
MS24694-C52 SCREW  
(1 PER SIDE)

**D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD**  
(MAKE FROM D3887-11)

RELEASED  
2013-03-19  
MD

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DB	D3887	SHEET 2 OF 8
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	A119 STD SKIDTUBE ASSY	NTS
DATE	13.02.19	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

AN3C5A BOLT  
D3672-1 PHENOLIC WASHER  
NAS1149C0332R WASHER  
(1 PER SIDE)

SEAL WITH  
SIKAFLEX-241/291

D2855-3 CAP

D3847-11  
WEARPAD

D3847-047  
AFT WEARPLATE ASSY

AN3C5A BOLT  
NAS1149C0332R WASHER  
30 PL

D3847-045  
CENTER WEARPLATE ASSY

D3847-043  
FWD WEARPLATE ASSY

D3847-1  
WEARPAD  
5 PL

BLACK ANTI-SKID TO 0.5  
ABOVE LOCATION RIDGE  
TYP

11  
Ø 0.197  
8 PL PER SIDE  
REF

D2855-3 CAP

SEAL WITH  
SIKAFLEX-241/291

MS24694-C52 SCREW  
(1 PER SIDE)

**D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE**  
(MAKE FROM D3887-11)

RELEASED  
2013-03-19

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	DB	D3887	SHEET 3 OF 8
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	A119 STD SKIDTUBE ASSY	NTS
DATE	13.02.19	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

AN3C5A BOLT  
D3672-1 PHENOLIC WASHER  
NAS1149C0332R WASHER  
(1 PER SIDE)

SEAL WITH  
SIKAFLEX-241/291

D2855-3 CAP

AN3C46A BOLT  
D3904-1 WASHER, 2 PL  
MS21043-3 NUT  
8 PL

BLACK ANTI-SKID TO 0.5  
ABOVE LOCATION RIDGE  
TYP

1.5  
1.5  
1.5

2.00 DISTANCE TO D3885-1 WEB

1.5  
1.5

D2855-3 CAP

SEAL WITH  
SIKAFLEX-241/291

MS24694-C52 SCREW  
(1 PER SIDE)

D3849-043  
AFT TRAINING WEARPLATE ASSY

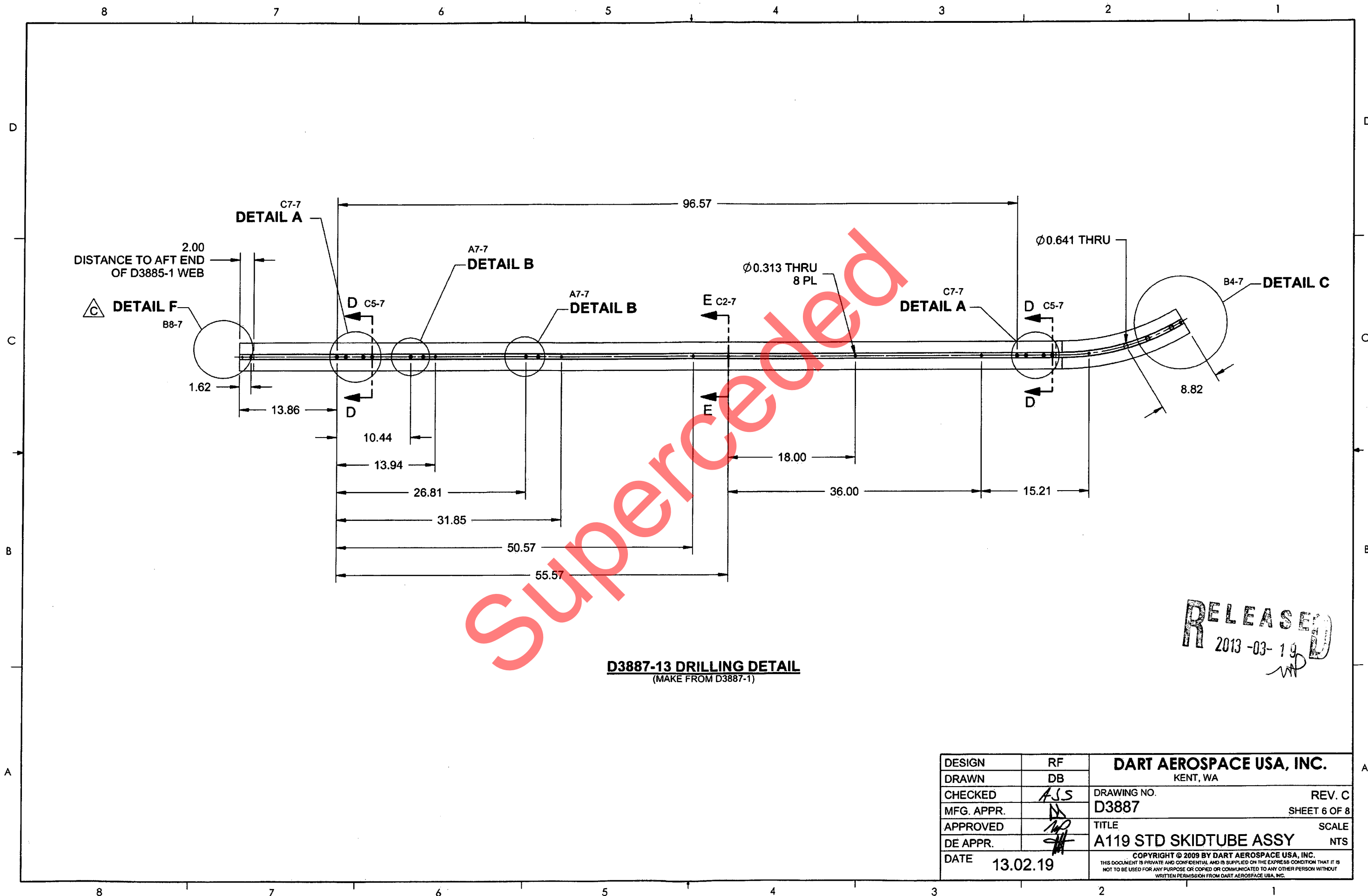
D3849-041  
FWD TRAINING WEARPLATE ASSY

**D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE**  
(MAKE FROM D3387-13)

RELEASED  
2013-03-19  
MD

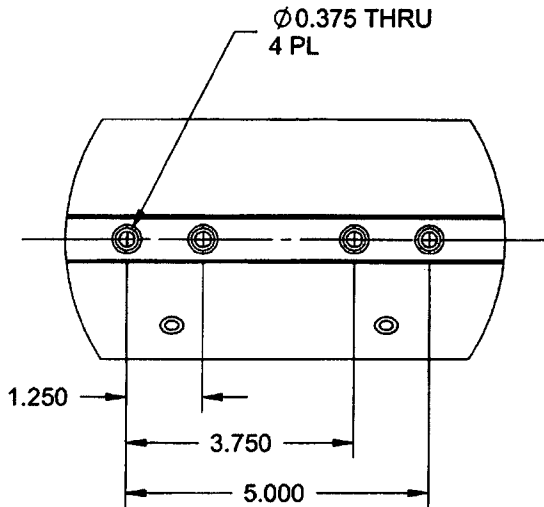
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	N	D3887	SHEET 4 OF 8
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	A119 STD SKIDTUBE ASSY	NTS
DATE	13.02.19	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



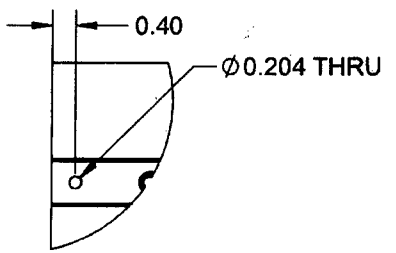


DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	DB		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	ND	D3887	SHEET 6 OF 8
APPROVED	MD	TITLE	SCALE
DE APPR.	SH	A119 STD SKIDTUBE ASSY	NTS
DATE	13.02.19	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

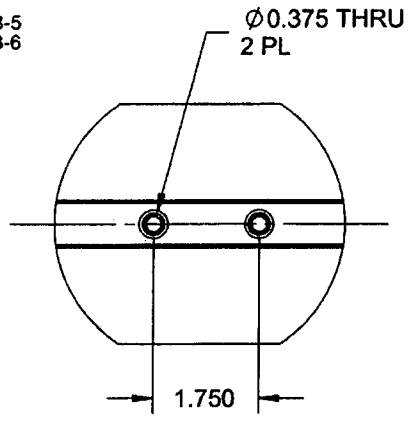




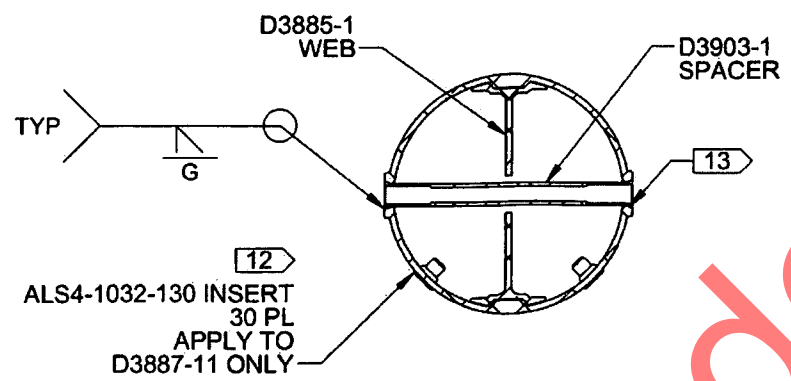
**DETAIL A**  
SCALE 4X  
D7-5  
C3-5  
D7-6  
C3-6



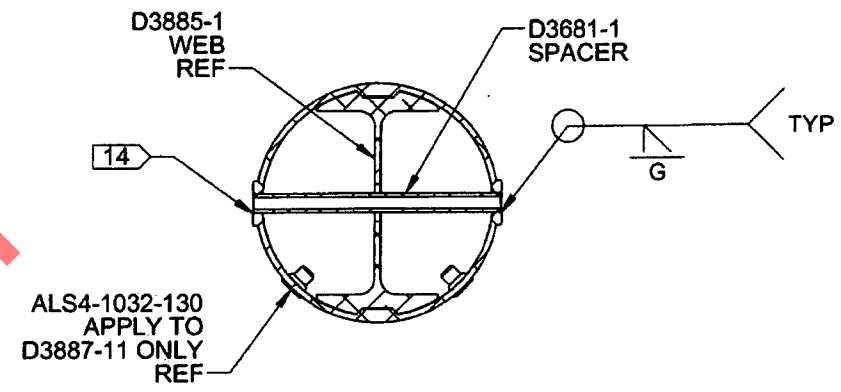
**DETAIL F**  
SCALE 4X  
C8-5  
C8-6



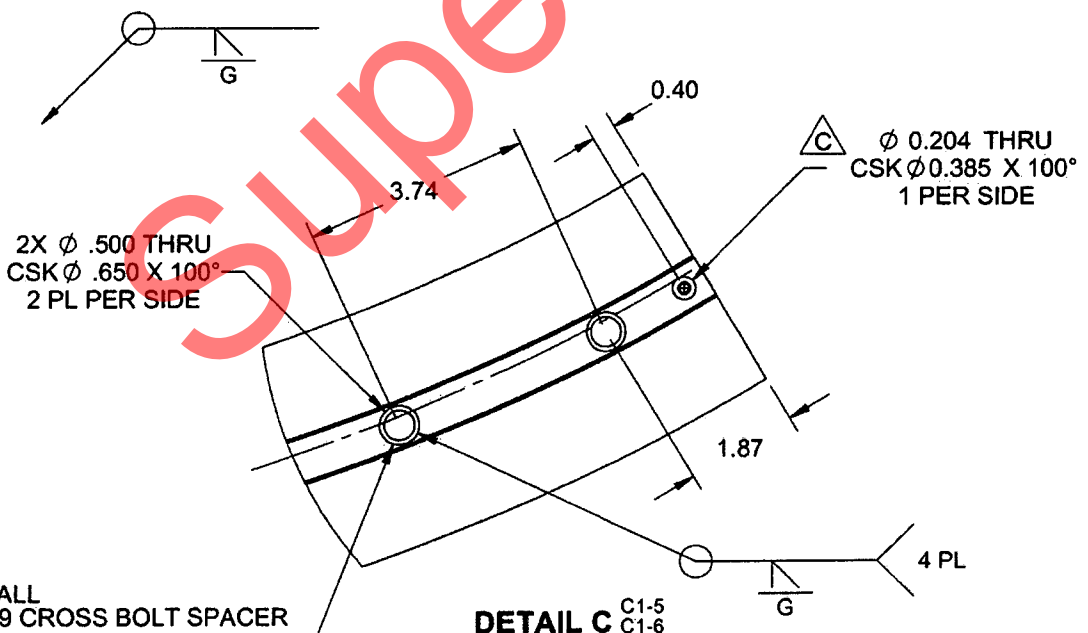
**DETAIL B**  
SCALE 4X  
C6-5  
C5-5  
C6-6  
C5-6



**SECTION D-D**  
SCALE 4X  
(FOR 12 X Ø0.375 HOLES PER SKIDTUBE)  
C7-5  
C3-5  
C7-6  
C2-6



**SECTION E-E**  
SCALE 4X  
(FOR 8 X Ø0.313 HOLES PER SKIDTUBE)  
C4-5  
C4-6



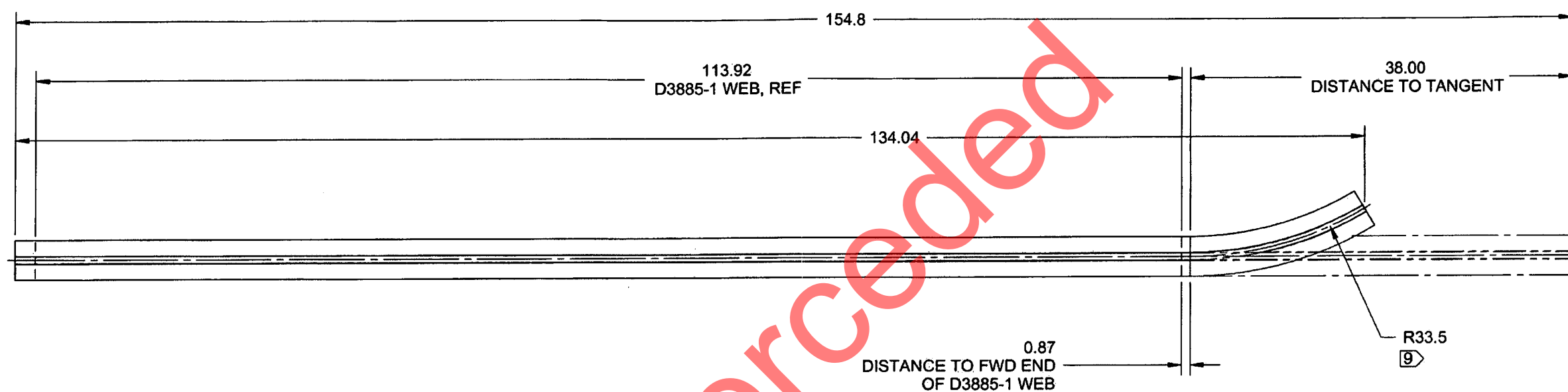
**DETAIL C**  
TYPICAL  
SCALE 4X  
C1-5  
C1-6

**INSTALL**  
D2579 CROSS BOLT SPACER  
2 PL

- NOTES:**
- 13) AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
- i) CHAMFER HOLES Ø0.475 x 45°
  - ii) INSERT D3903-1 SPACER
  - iii) WELD INTO PLACE AND GRIND FLUSH
  - iv) C'BORE TO 0.313 x 0.75 DEEP
  - v) DEBURR HOLES
- 14) AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.313 HOLES ONLY:
- vi) CHAMFER HOLES Ø0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
  - vii) INSERT D3681-1 SPACER
  - viii) WELD INTO PLACE AND GRIND FLUSH
  - ix) DEBURR HOLES

**RELEASED**  
2013-03-19

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DB	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DB	D3887	SHEET 7 OF 8
APPROVED	49	TITLE	SCALE
DE APPR.	49	A119 STD SKIDTUBE ASSY	NTS
DATE	13.02.19	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



**D3887-1 BEND DETAIL**  
(MAKE FROM D2500-1-190 EXTRUSION)

**RELEASED**  
2013-03-19  
*MP*

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DB	KENT, WA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DB</i>	<b>D3887</b>	SHEET 8 OF 8
APPROVED.	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>A119 STD SKIDTUBE ASSY</b>	NTS
DATE	13.02.19	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	